

Date: Thursday, 5/3/2007 11:38:53 AM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|-------------------------------------|------------------|------------------|--|--|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | TUBE ASSEMBLY 6" | | |
| Job Number | 32202 | | | | |
| Estimate Number | 11194 | | | | |
| P.O. Number | N/A | Part Number | D3298009 | | |
| This Issue | 5/3/2007 | S.O. No. | N/A | | |
| Prsht Rev. | NC | Drawing Number | D3298 REV A2 | | |
| First Issue | N/A | Project Number | N/A | | |
| Previous Run | 28230 | Drawing Revision | A2 | | |
| Written By | <i>JLJ 07/05/07</i> | | | | |
| Checked & Approved By | | | | | |
| Comment | Est A 04.09.08 New issue KJ/JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|------------------|--------------------------|
| 1.0 | M6061T6T0375W035 | 6061-T6 Tube .375 x.035W |
|-----|------------------|--------------------------|


✓

Comment: Qty.: 0.5250 f(s)/Unit Total : 2.6250 f(s)

Cut tube to length as per Dwg D3298

Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)

Identify as D3298-009

Batch: M103646

mlo7/05/07

| | | |
|-----|-----------|--------|
| 2.0 | MS208196D | Sleeve |
|-----|-----------|--------|


✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Sleeve

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------------------|
| 1 | MS20819-6D | Sleeve | <u>M103044 X5</u> |

| | | |
|-----|---------|-----|
| 3.0 | AN8186D | Nut |
|-----|---------|-----|


✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Coupling Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 1 | AN818-6D | Nut | <u>M103154</u> |

mlo7/05/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/15
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:38:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 6"

Job Number: 32202

Part Number: D3298009

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

x5

10

ml07/05/07

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/05.10(5)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 5182

10/05.11(5)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/05.15

Job Completion



10/05.14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------------|------|--|-----------------------------|---------------------------------|-----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/05/06 4.0 | | 3 parts scrap, Flare not made as per drawing and parts were buff to much | QS/04/L | destroy part and replace | MJL 07/05/15 | 07/05/10 | QS/04/L | QS/05-10 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



ACOPY
OF THIS
DRAWING

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>R7</i> | DRAWN BY <i>JF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CH</i> | APPROVED <i>CH</i> | DRAWING NO. D3298 | REV. A SHEET 1 OF 7 |
| DATE 04.07.06 | | TITLE TUBE ASSEMBLIES | SCALE NTS |

RELEASED
04.09.09

| | | |
|----|------------------------|---|
| A | 04.07.06 | NEW ISSUE |
| A1 | CH 04.11.30 | CORRECT VIEW D3298-003; 16.50 WAS 15.75 |
| A2 | CH 05.05.06 | FOR D3298-001/-003 16.00 WAS 16.50 |

| P/N | TEMPLATE | CUT LENGTH OF TUBE | MS20819-6D SLEEVE | AN818-6D NUT | DESC. | MATERIAL |
|-----------|-------------|-----------------------|-------------------|--------------|------------|---|
| D3298-001 | D3298-001T1 | 25.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-003 | D3298-003T1 | 27.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-005 | D3298-005T1 | 23.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-007 | D3298-007T1 | 8.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-009 | D3298-009T1 | 6.00 | 1 | 1 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-011 | D3298-011T1 | 8.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-013 | D3298-013T1 | 10.00 | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |
| D3298-015 | D3298-015T1 | 14.00 | 1 | 1 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W (WW-T-700/6) |

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

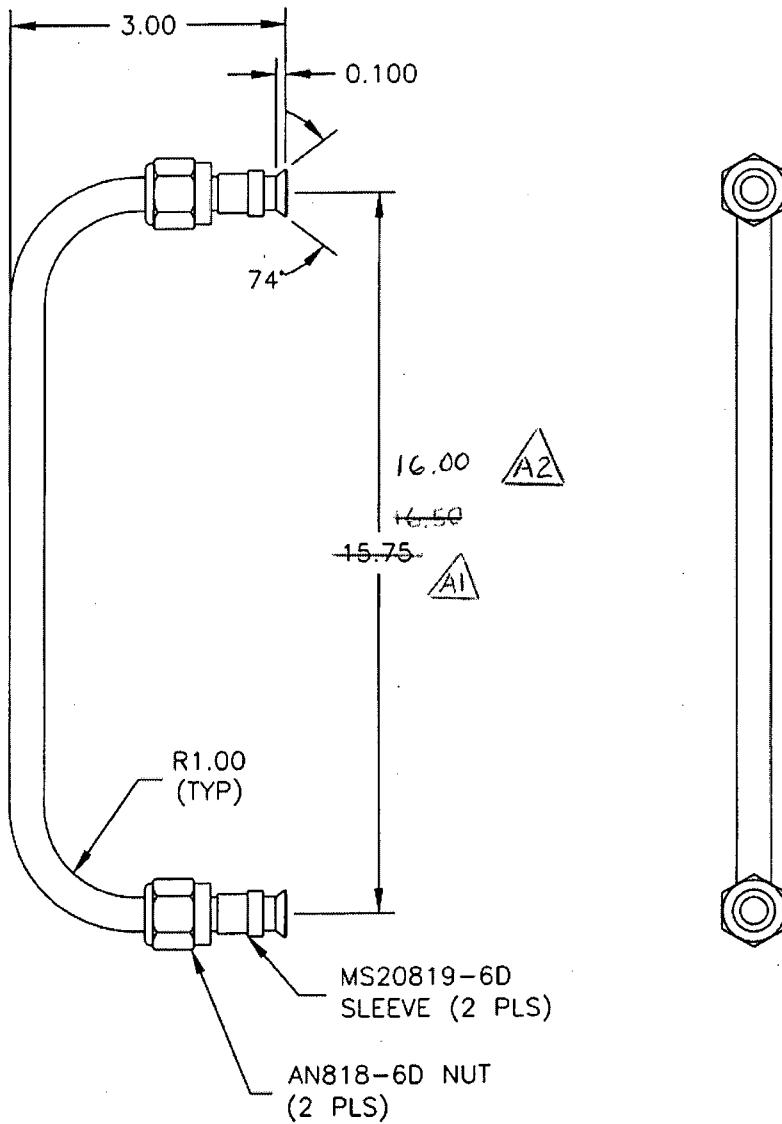
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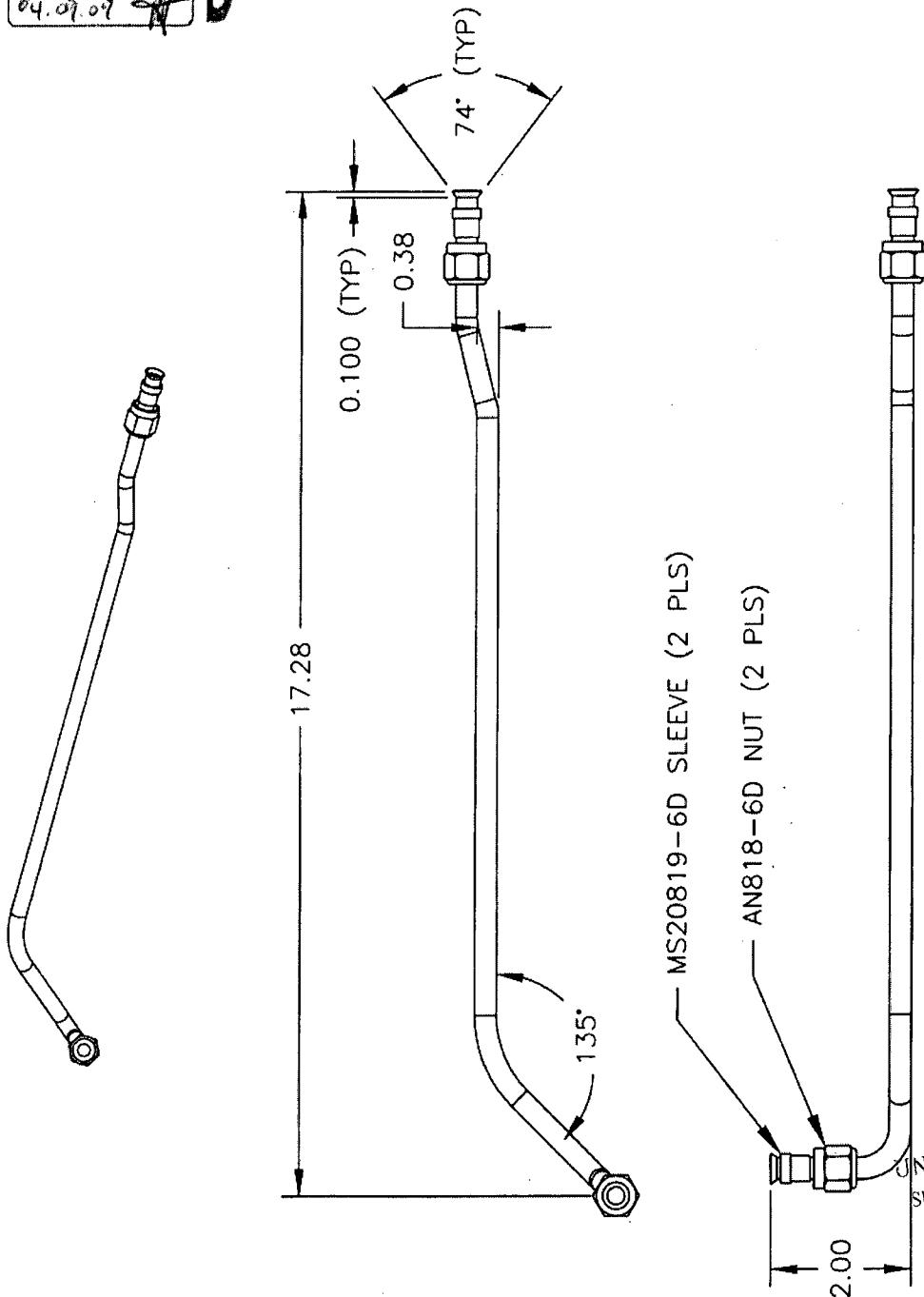
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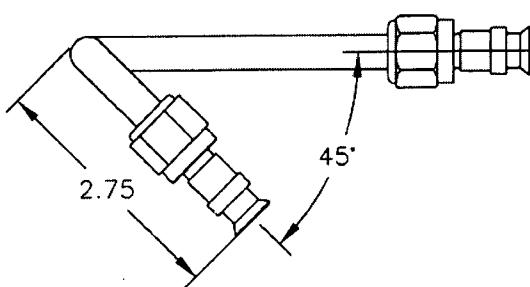
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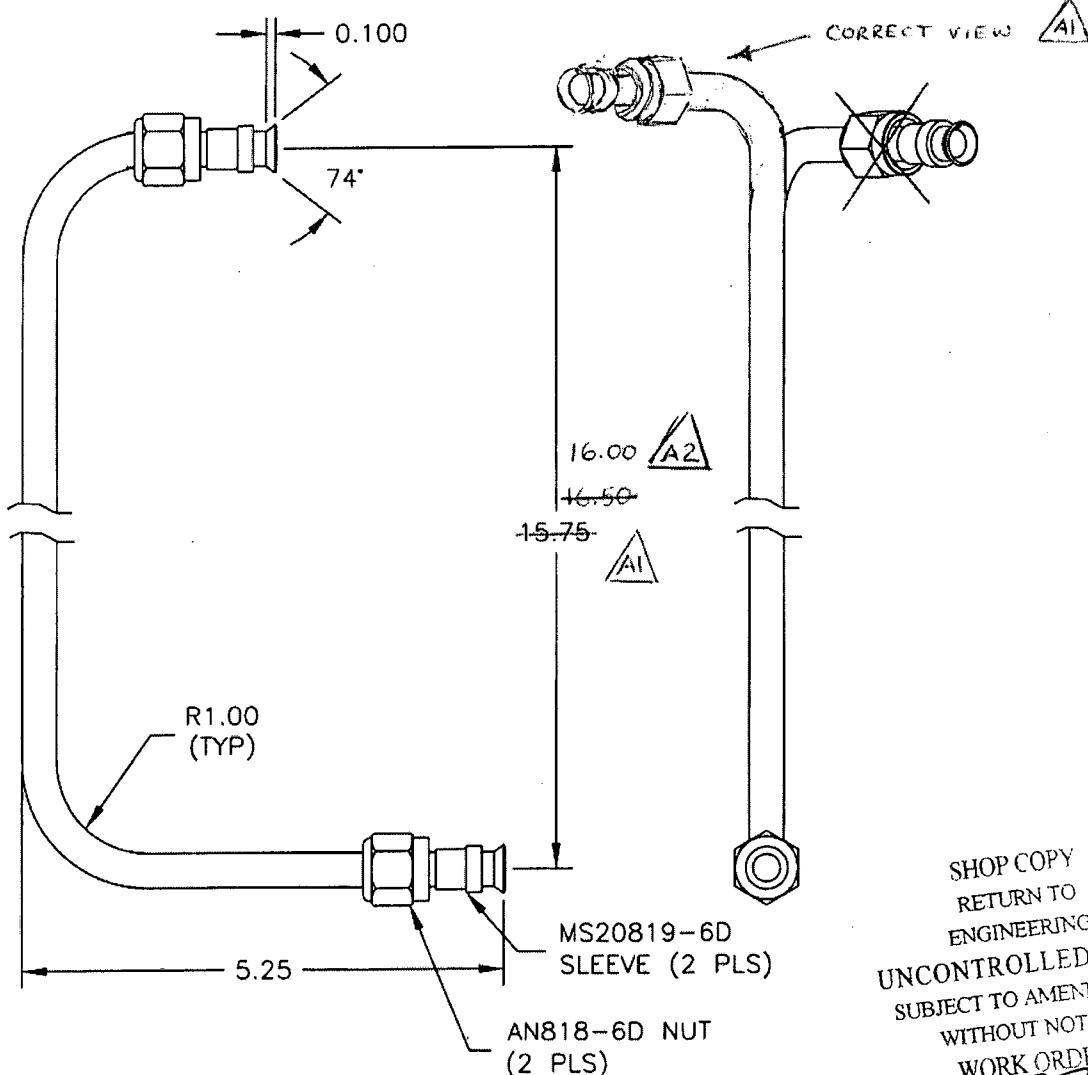
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D3298-003



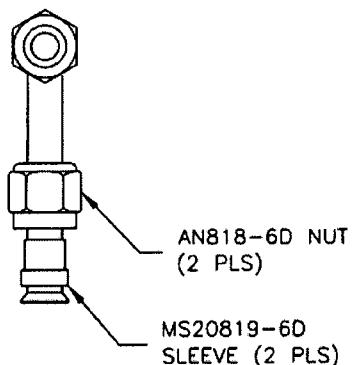
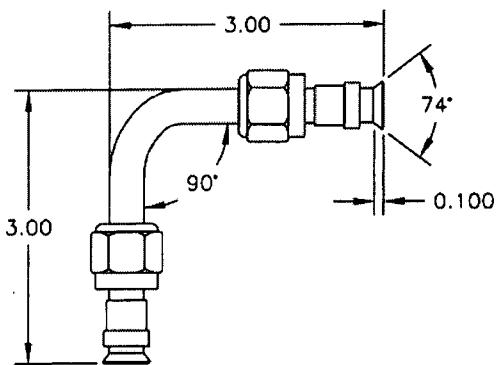
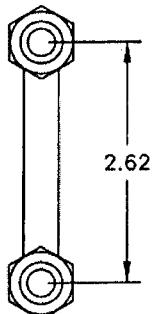
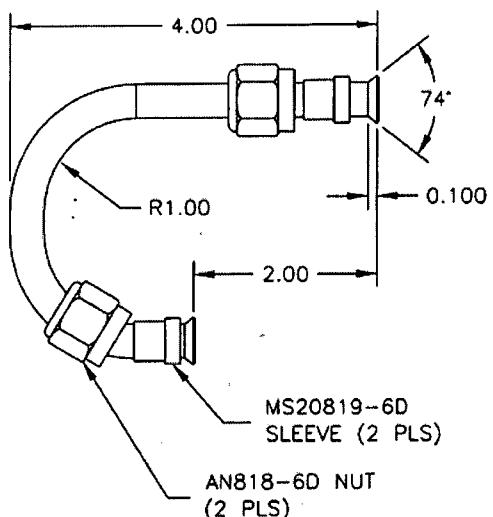
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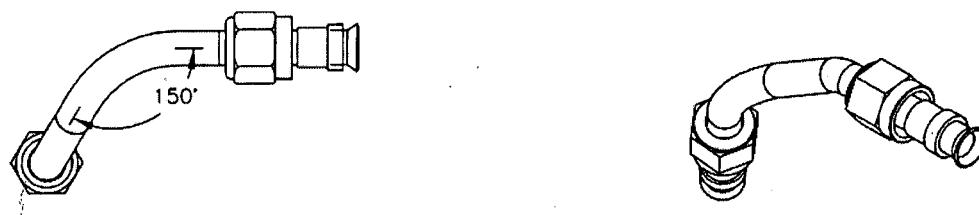
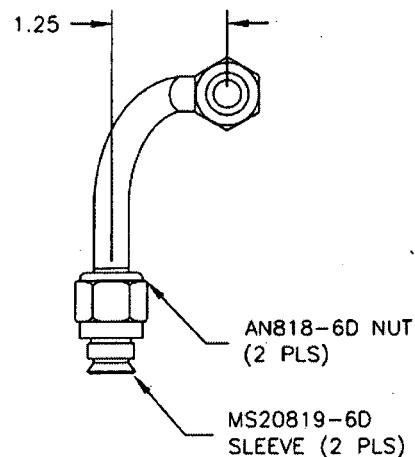
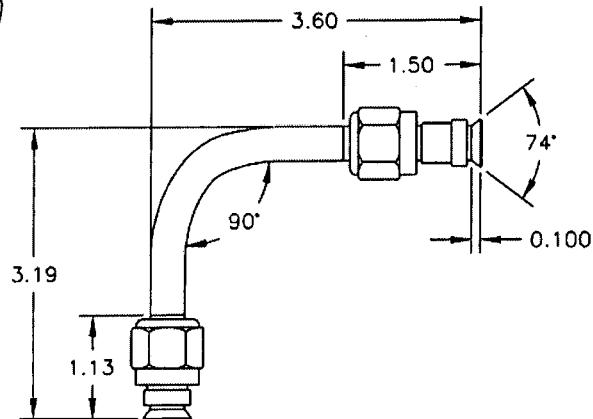
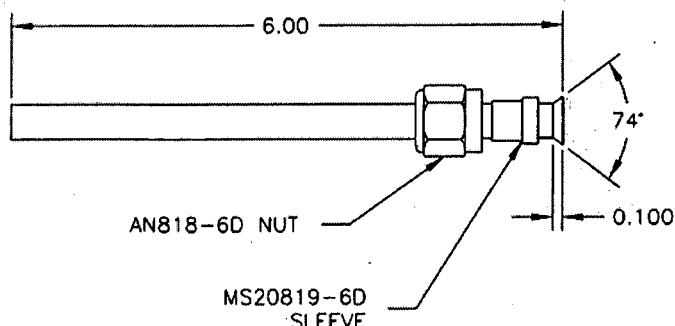
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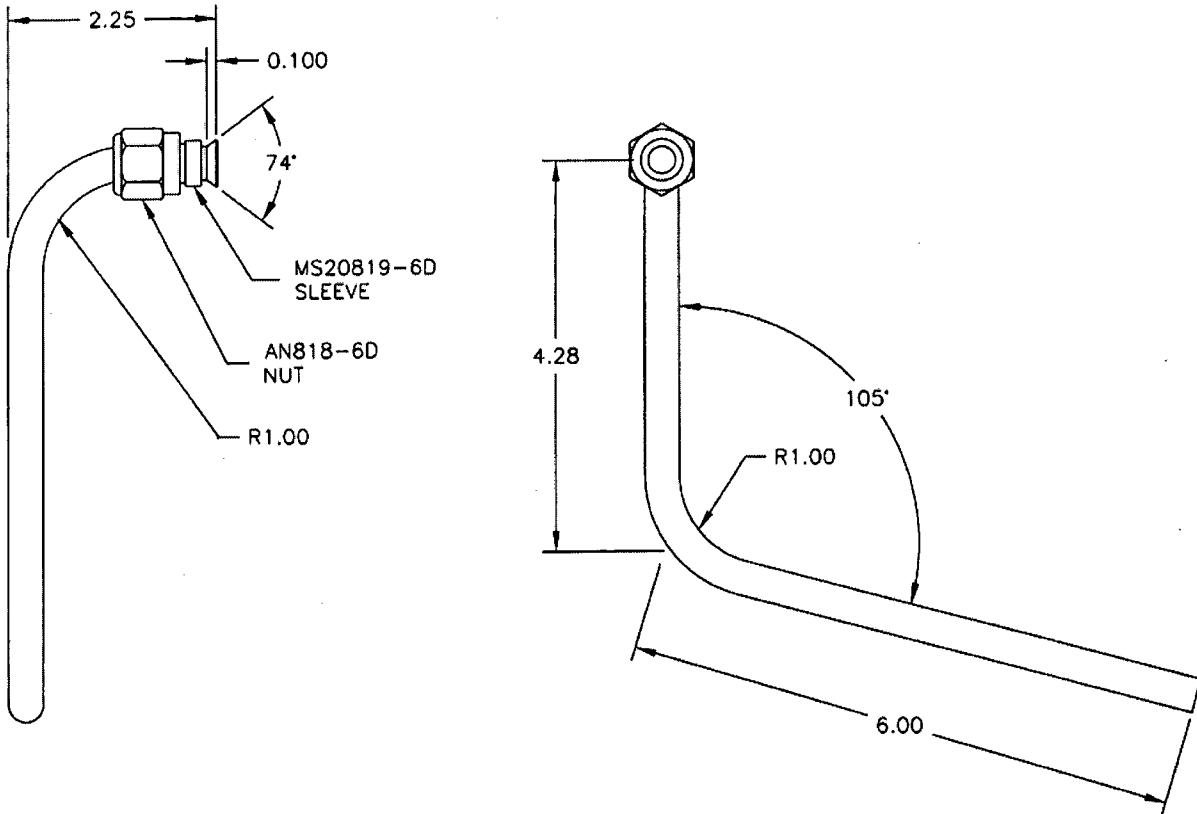
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